

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3208-041 PAR #: N/A Fault Category: machining NCR: Yes No DQA: 11 Date: 11.10.25
11-911 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CK Date: 11/10/25

NCR:		WORK ORDER NON-CONFORMANCE (NCR) <u>47.56 x 2 = 95.12</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/10/11	100	Blank was too short R.L. cut in saw too short. 45A.	S 11/10/12 Q57012	Part was replaced + scrapen QH x1 B <u>118400</u>	P.K. 11/10/11	S 11/10/12 Q57012	S 11/10/12 Q57012	S 11/10/12
11/10/12	100	QH x1 Part machined too short. Should be 1.832" But measured 1.838" R.L. first part. Place worn in vise operator error	J 11/10/12 Q51092	Scrap + Destroy + no replace QH x1	P.K. 11/10/12	S 11/10/12	J 11/10/12	S 11/10/12

NOTE: Date & initial all entries

Work Order ID 74723

Wednesday, October 05, 2011 1:58:47 PM



Page 2

Item ID: D3209-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 10/5/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B.A 11/10/13

5

0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

5 0 11/10/13

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

5X 0 m 11/10/13

Note: Cover the hole for D3209-1 before powder coat. ☐ START TIME: 1:40 ☐ OVEN TEMPERATURE:

☐ FINISH TIME: 1:40

M118489

320

1:40

Dart Aerospace Ltd

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Work Order ID 74723

Wednesday, October 05, 2011 1:58:47 PM



Page 4

Item ID: D3209-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 10/5/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo	0.00 0.00							<u>9/11/10/17</u> (S)
190 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>11/10/18</u> (S)

11-10-15 (S)

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 05, 2011 1:58:52 PM

Page 1

Work Order ID: 74723

Parent Item: D3209-041

Parent Item Name: Bracket Assembly





Start Date: 10/5/2011

Required Date: 10/14/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A 04.06.09 New issue KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3209-3  Bushing		Manufactured	No			100	Each	34.0000	1	6		9/11/10/17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST041		34							
				40930		34							
M6061T6B1.500X01.25 0		Purchased	No			170	f	12.1120	0.175	1,105263			
 6061-T6 Bar 1.50 x 1.25												11-10-06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT004		12.112							
				118071		0.112							
				118400		12							

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	74723
Description: Bracket		Part Number:	D3209-1
Inspection Dwg: D3209 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <i>E.K. / [signature]</i>	Audited by: <i>BA</i>	Prototype Approval:	N/A
Date: <i>12/10/11</i>	Date: <i>11/10/13</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue (P/O D3209-041)	KJ/JLM	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

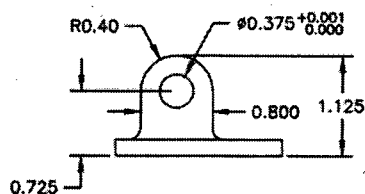
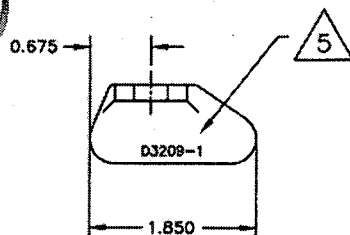
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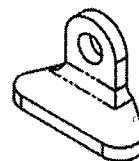
DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED TF	APPROVED TF	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05



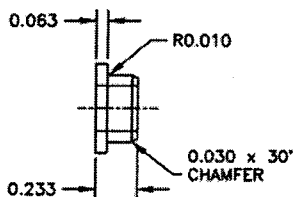
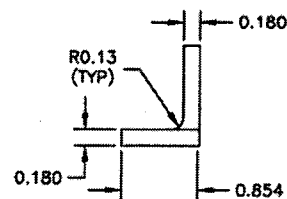
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D3209-1 BRACKET



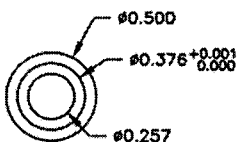
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74723

MLJ
11/10/05



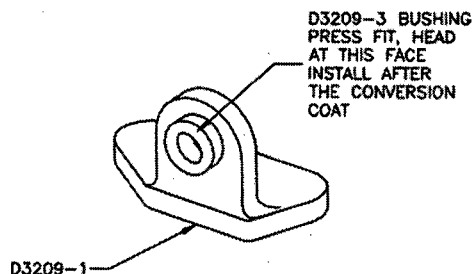
3

**D3209-3 BUSHING
SCALE 1:2**



4

D3209-041 ASSEMBLY



D3209-1 BRACKET: D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

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